

What is claimed is:

1. A grinding wheel comprising an abrasive grain layer formed by firmly fixing abrasive grains to an end face of a cup-shaped core by brazing, wherein:

a circumferentially continuous groove is formed in a substantially central portion
5 of said end face of said core; and

said abrasive grains are firmly fixed to an end face portion excluding regions near an outer rim and an inner rim of said end face and a boundary with said groove under the condition that, with respect to all the abrasive grains, skirts of a brazing material layer for holding the abrasive grains have a length one or more times an average grain size of the
10 abrasive grains.

2. The grinding wheel according to claim 1, wherein an outside region and an inside region divided in two by said groove are intended for coarse grinding and finish grinding, respectively, and either or both of grain size and interval of arrangement of said
15 abrasive grains are changed between the inside region and the outside region.

3. The grinding wheel according to claim 2, wherein flat portions are formed on extremities of said abrasive grains on the inside region.